

# Work Order ID 63254

Tuesday, October 26, 2010 3:03:31 PM



Page 1

Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 10/26/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 11/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

*AL*

Date: 10-10-26 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2506	Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506  
Debur if necessary

☐ Dwg Rev:

*F*

☐ Prog Rev:

*F*

☐ 2-

*304 1.040*

*HB 10-10-27*

*(6)*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*HB 10-10-27*

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

*8/10/10/28*

*(+6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Stop



Start Date: 10/26/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 11/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Brake NC

Memo

1-Form as per dwg D2506

0.00

SB 10/10/02

6

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

S 10/10/02

46

150



Packaging

Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

SAD  
10-11-02

6

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63254**

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Page 3

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Cust Item ID:

Required Date: 11/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/09 [Signature]  
mr  
10-11-9



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, October 26, 2010 3:03:35 PM

Page 1

Work Order ID: 63254



Parent Item: D2506



Parent Item Name: Label Plate

Start Date: 10/26/2010

Required Date: 11/4/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 01.06.08 Now laser cut EC  
IPP C 06.12.13 ecn 822 ec  
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	176.7000	1.22	6.421053			



304/316 .040 Sheet



1310-10-07

## Location

## Loc Qty

## Loc Code

MAT

172.7

115762

12.7

115953

160

MAT20

4

113062

1.398

115440

2.602

115953



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**D2506 LABEL PLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43254  
Bf10-10-24

RELEASED  
08/11/18

**NOTES**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT. UPDATED NOTE, 1 (ZN A5-1); ADDED DETAIL A (ZN C8-2); 124" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.53 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1/55		
CHECKED	1/55	DRAWING NO.	REV. F
MFG. APPR.	1/55	D2506	SHEET 1 OF 2
APPROVED	1/55	TITLE	SCALE
DE APPR.	1/55	LABEL PLATE	NTS
DATE	08.09.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE COMPANY CONDITIONED BY THE FACT OTHER USERS MAY HAVE REPRODUCED OR COPIED OR OTHERWISE USED THE SAME WITHOUT PERMISSION OF THE COMPANY.	

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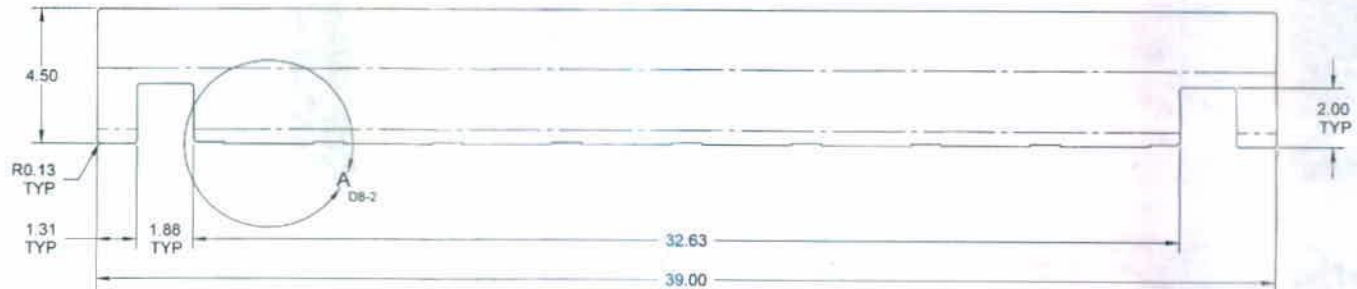
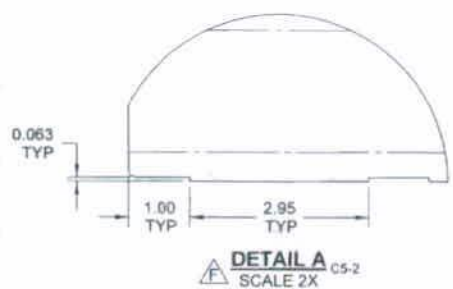
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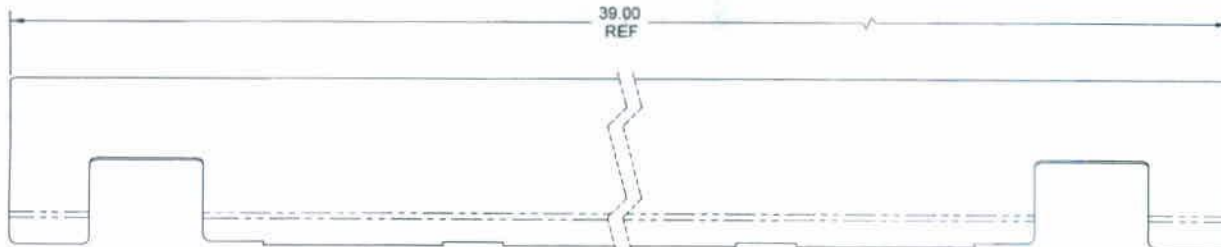
**NOTE:** Date & initial all entries



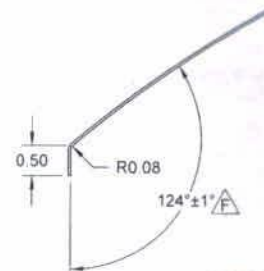
w/o 43254



**D2506-F LABEL PLATE**  
(FLAT PATTERN)



**D2506 LABEL PLATE**  
(MAKE FROM D2506-F)



**RELEASED**

DESIGN	BYV	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2506	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LABEL PLATE	NTS
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